SPLIT.

Work Order ID 67661 – 2

Tuesday, March 29, 2011 9:22:18 AM

Item ID: D2574 **Accept** **Setup Start**

Revision ID:

Item Name: Saddle, Aft In 205 **Stop**

Start Date: 3/30/2011 **Start Qty:** 12.00 6 **Cust Item ID:**

Required Date: 4/13/2011 **Req'd Qty:** 12.00 **Customer:**

Reference:

Approvals: **Process Plan:** MMF **Date:** 11-03-2011 **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D2574	Revision Nbr: Rev E								
100 HAAS 1	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS CNC vertical machine #1	Memo: Program Batch No 67661 Double check by JL 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp	0.00							
						B.A 11/04/05	6	1	
110 Mill Conv	CONVENTIONAL MILLING MACHINE	0.00							
Conventional Milling Machine	Memo: Machine keyway as per dwg D2573 & D2574	0.00							
						B.A 11/04/05	6		
						Rq 11.5.10			
120 QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00							
						B.A 11/04/06	6		
						Rq 11.5.10			

P+O →

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2574 PAR #: N/A Fault Category: Machining NCR: (Yes) No DQA: JL Date: 11.07.20

11-614 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/07/24

NCR: 67661-2	WORK ORDER NON-CONFORMANCE (NCR)							# 181.51
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.05.05	100	Saddle-to-skd surface off by .020-.030 BECAUSE of offset. RC: process	GP 11.05.05 DS1042	SCRAP REPLACE batch#: B66966	B.A 11/05/05	JL 11/05/16	GP 11.05.05 DS1042	S 11/07/19

NOTE: Date & initial all entries

Work Order ID 67661

Tuesday, March 29, 2011 9:22:19 AM

Item ID: D2574 Accept Setup Start

Revision ID:

Item Name: Saddle. Aft In 205 Stop

Start Date: 3/30/2011 Start Qty: 12.00 Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00 Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date: Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QS1005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
150	White Glass(Ref:4.3.5.1) per QS1005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:30 FINISH TIME: 3:00	OVEN TEMPERATURE: 320							

SL 11/05/16

(6)

6x ø m-L 11/05/16

6x ø m-L 11/05/16

MM116964

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67661

Tuesday, March 29, 2011 9:22:19 AM

Item ID: D2574 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Saddle, Aft In 205

Start Date: 3/30/2011 **Start Qty:** 12.00 **Cust Item ID:**

Required Date: 4/13/2011 **Req'd Qty:** 12.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				6			BL 11-5-16.
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location 434	0.00							11/5/16 DSP
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							11/5/18
QC	Memo	0.00							
Quality Control									

RR 11-05-16 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 9:22:16 AM

Work Order ID: 67661

Parent Item: D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 3/30/2011 **Required Date:** 4/13/2011

Start Qty: 12.00 **Required Qty:** 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	87.0000	1	12			

Saddle Billet

Location	Loc Qty	Loc Code	
MAT045	30		
66966	30		
MAT046	57		
65382	17		5
65953	20		4
66966	20		3

B.A 11/04/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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DART AEROSPACE LTD	Work Order:	07661
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443						Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.002	8.002	8.002	8.002	Vern	CNC-02
F	0.490	0.510		.499	.495	.498	.497	Vern	GA-01
G	0.257	0.262		0.259	0.259	0.259	0.259	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		0.501	.501	.503	.503	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		0.568	.569	.568	.568	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.365	1.375		1.370	1.370	1.370	1.370	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	4.119	4.129		4.124	4.124	4.124	4.124	"	"
P	0.115	0.135		.128	.128	.125	.126	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		.255	.255	.255	.255	"	"
S	0.115	0.135		.122	.119	.122	.122	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-G	ref.
U	3.210	3.250		3.230	3.230	3.230	3.230	Vern	GA-01
V	0.230	0.250		.241	.241	.241	.241	"	"
W	0.115	0.135		.125	.125	.125	.125	Mic	118-120
X	0.307	0.312		0.310	0.310	0.310	0.310	Vern	GA-01
Y	0.760	0.765		0.764	0.764	0.764	0.764	"	"
Z	0.352	0.372		.367	.367	.367	.367	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-G	ref.
AB	0.615	0.635		.627	.627	.627	.627	Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0063	R-G	ref.
AD	0.240	0.260		.255	.255	.255	.255	Vern	GA-01
AE	1.500	1.520		1.5126	1.5125	1.511	1.511	H-G	31006
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		.256	.256	.256	.256	"	"
AH	0.240	0.260		.254	.254	.254	.254	"	"
AI	2.000	2.020		2.003	2.0025	2.002	2.002	H-G	31006
AJ	0.023	0.043		0.033	0.033	0.033	0.033	Vern	GA-01
Accept/Reject									

Measured by:	V.A
Date:	11/04/05

Audited by	JL
Date:	11/05/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	67661
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	87	48	By	Date
A	0.438	0.443						Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.002	8.002	8.002	8.002	Vern	CNC-02
F	0.490	0.510		.495	.495	.500	.498	Vern	GA-01
G	0.257	0.262		0.259	0.259	0.259	0.259	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		.501	.501	.502	.502	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		.568	.568	.568	.568	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.365	1.375		1.370	1.370	1.370	1.370	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	4.119	4.129		4.124	4.124	4.124	4.124	"	"
P	0.115	0.135		.124	.125	.125	.125	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		.255	.255	.255	.255	"	"
S	0.115	0.135		.126	.124	.123	.123	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	3.210	3.250		3.230	3.230	3.230	3.230	Vern	GA-01
V	0.230	0.250		.241	.241	.241	.241	"	"
W	0.115	0.135		.130	.130	.130	.130	Mic	118-120
X	0.307	0.312		0.310	0.310	0.310	0.310	Vern	GA-01
Y	0.760	0.765		0.764	0.764	0.764	0.764	"	"
Z	0.352	0.372		.367	.367	.367	.367	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		.627	.627	.627	.627	Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		.255	.255	.255	.255	Vern	GA-01
AE	1.500	1.520		1.511	1.511	1.511	1.511	H-6	31006
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		.256	.256	.256	.256	"	"
AH	0.240	0.260		.254	.254	.254	.254	"	"
AI	2.000	2.020		2.002	2.002	2.002	2.002	H-6	31006
AJ	0.023	0.043		0.033	0.033	0.033	0.033	Vern	GA-01
Accept/Reject									

Measured by:	RF
Date:	11.5.16

Audited by	SL
Date:	11/05/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	67661
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12	By	Date
A	0.438	0.443		.438	.438	.438	.438	Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.000	8.000	8.000	8.000	Vern	CMC-02
F	0.490	0.510		.499	.494	.493	.495	Vern	GA-01
G	0.257	0.262		0.259	0.259	0.259	0.259	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		.502	.502	.502	.503	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		.568	.568	.568	.568	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.365	1.375		1.370	1.370	1.370	1.370	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	4.119	4.129		4.124	4.124	4.124	4.124	"	"
P	0.115	0.135		.125	.125	.123	.125	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		.255	.255	.255	.255	"	"
S	0.115	0.135		.123	.123	.123	.123	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	3.210	3.250		3.230	3.230	3.230	3.230	Vern	GA-01
V	0.230	0.250		.241	.241	.241	.241	"	"
W	0.115	0.135		.130	.130	.130	.130	Mic	118-120
X	0.307	0.312		0.310	0.310	0.310	0.310	Vern	GA-01
Y	0.760	0.765		0.764	0.764	0.764	0.764	"	"
Z	0.352	0.372		.367	.367	.367	.367	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		.627	.627	.627	.627	Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		.255	.255	.255	.255	Vern	GA-01
AE	1.500	1.520		1.510	1.510	1.510	1.510	H-6	31006
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		.254	.254	.254	.256	"	"
AH	0.240	0.260		.254	.254	.254	.254	Vern	GA-01
AI	2.000	2.020		2.002	2.002	2.002	2.002	H-6	31006
AJ	0.023	0.043		0.033	0.033	0.033	0.033	Vern	GA-01
Accept/Reject									

Measured by:	RF
Date:	11.5.11

Audited by	JL
Date:	11/05/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

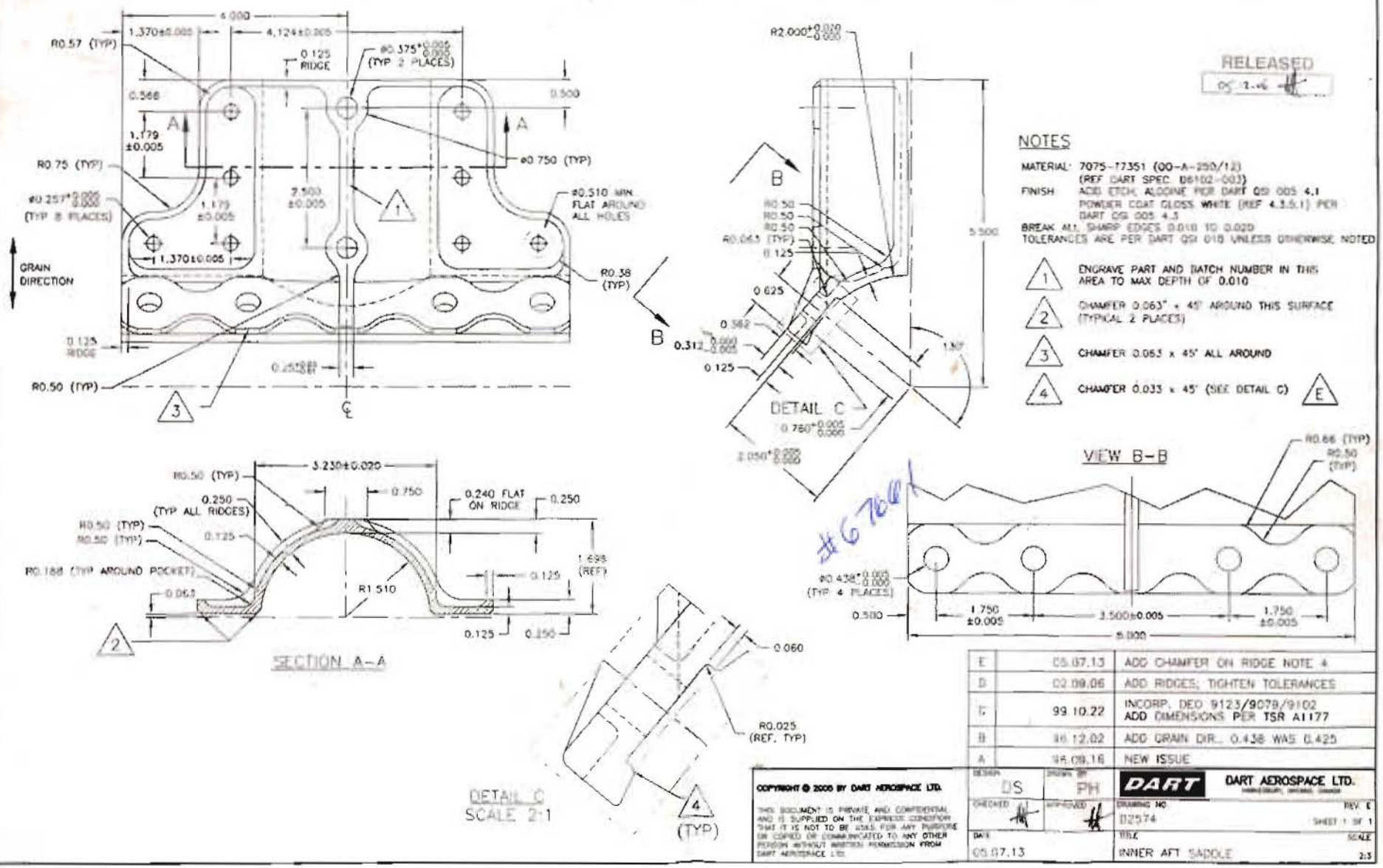
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & Initial all entries



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	98.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	98.09.16	NEW ISSUE

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DESIGN: DS	DRAWN BY: PH	DART AEROSPACE LTD.	
CHECKED	APPROVED	DRAWING NO. D2574	REV. E
DATE: 05.07.13		TITLE: INNER AFT SADDLE	SHEET 1 OF 1 SCALE 2:3

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Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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